

Work Order ID 70802

Page 1

Wednesday, June 15, 2011 11:27:46 AM

Item ID: D4151-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 6/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4151

C

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

11/06/15 (1)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/15

(70)

120

Identify as per dwg & Stock Location: 131

0.00



Packaging

Memo

0.00

Packaging

11/6/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Start Date: 6/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/16 JH
MK
11-06-15

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Picklist Print

Wednesday, June 15, 2011 11:27:51 AM

Page 1

Work Order ID: 70802

Parent Item: D4151-043

Parent Item Name: Basket Fwd Hardpoint Assembly, Upper




Start Date: 6/15/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.01.21 as per dwg revC DD verf:JLM
IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-3  Upper Hardpoint Plate		Manufactured	No			100	Each	3.0000	2	2		6/15/15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST118				3					
				66569				3					
D4151-7  Fwd Eyebolt Receiver (Upper)		Manufactured	No			100	Each	5.0000	1	1		6/15/15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST134				5					
				61233				1					
				68580				4					
AN4C13A  BOLT		Purchased	No			100	Each	35.0000	2	2		6/15/15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				35					
				117793				35					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 11:27:51 AM

Page 2

Work Order ID: 70802



Parent Item: D4151-043



Parent Item Name: Basket Fwd Hardpoint Assembly, Upper

Start Date: 6/15/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,207.000

2

2



EP 5/11/06/15

Nut

Location

Loc Qty

Loc Code

FG	40
104603	40
ST300	167
117423	167
ST301	1000
117601	500
117793	500

2

NAS1149C0432R

Purchased

No

100

Each

5,508.000

4

4



EP 5/11/06/15

Washer

Location

Loc Qty

Loc Code

ST297	5508
116900	508
117291	5000

4

Wednesday, June 15, 2011 11:27:51 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	ANMC13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70862

11-06-15

RELEASED
2011-01-08

D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

C	AM4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TO 1,000 DIM (C5-2, D1-2, C7-3, C5-3); Ø0.250 WAS Ø0.191 (C5-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5SD. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3811-1 (ZN B6-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) (ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D330-007-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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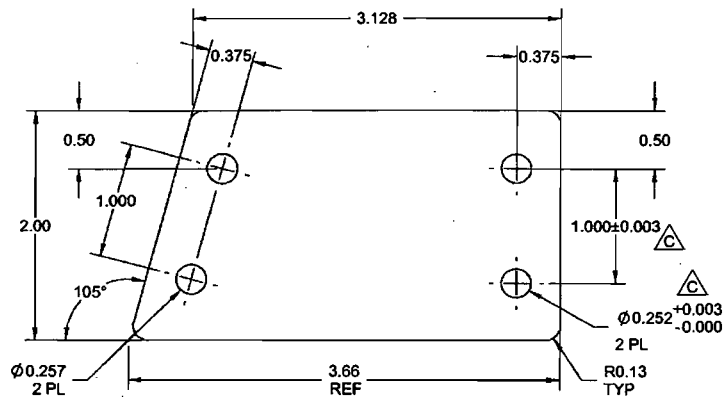
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

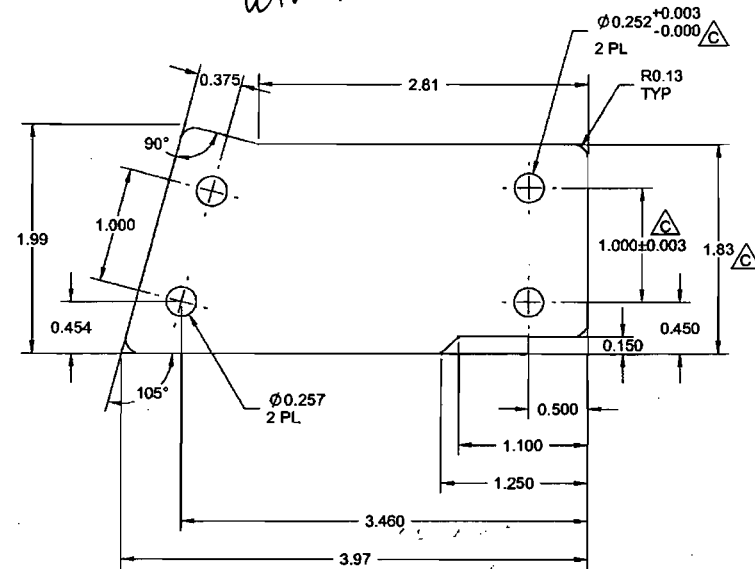
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NOTE: Date & initial all entries



0.125 REF
D4151-1 LOWER HARDPOINT PLATE



0.125 REF
D4151-3 UPPER HARDPOINT PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

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MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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RELEASED
R 2011-01-18
JMD

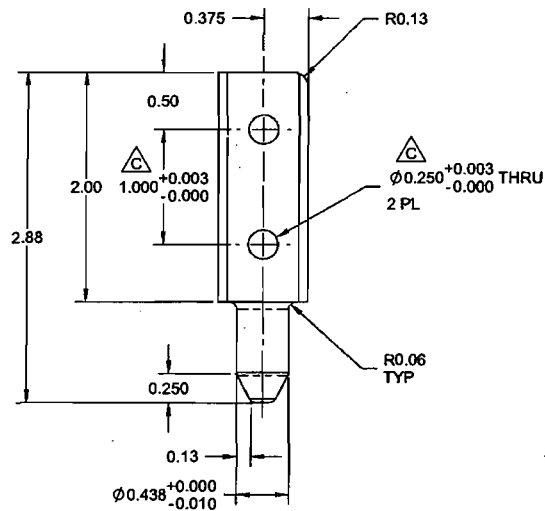
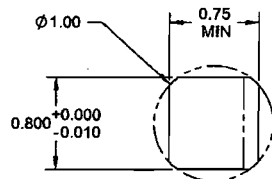
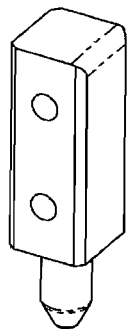
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

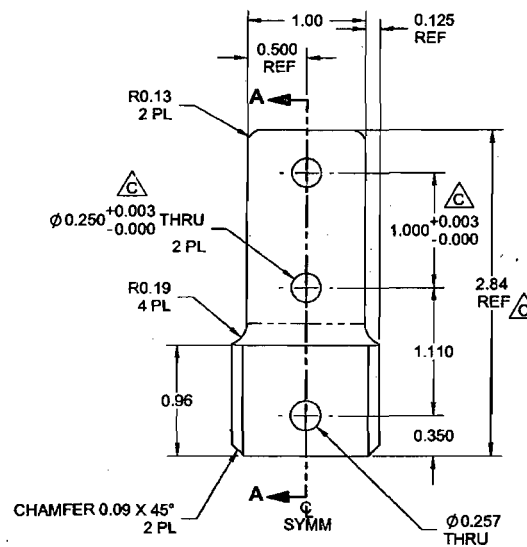
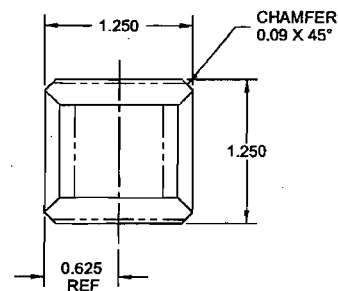
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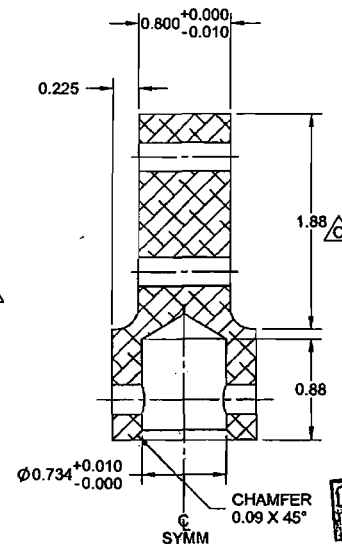
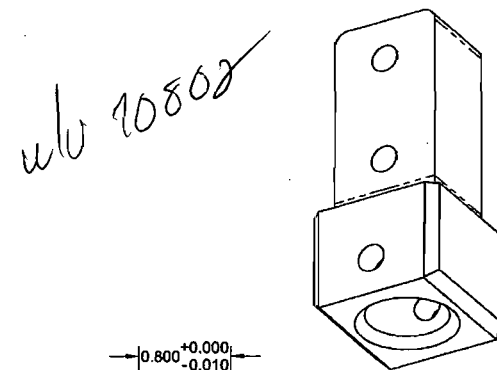
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

RELEASED
2011-02-13
RELEASED

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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